



Dart Aerospace Ltd.
1270 Aberdeen St
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D2971
Job Sheet 179144



Part No: D2971

Job Qty: 20 ea

Part Name: Cross Bolt Spacer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/14/18

Job Tracking No:

Due Date: 7/4/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A1 IPP B 02.11.04 Re-format; Ø0.875" x 0.058" was Ø0.625" x 0.065" KJ

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea		7/4/18	0.00	0.00	Start Up Machining-1		JBD
100	Hardinge	20 pcs		7/4/18	0.00	1.00	Hardinge		JBD
120	QC	20 pcs		7/4/18	0.00	0.00	QC8		2018-07-11
130	Packaging	20 pcs		7/4/18	0.00	0.00	Packaging3-1		BE
140	QC21-SA	20 Ea		7/4/18	0.00	0.00	QC21		

Part Op 100 - as per Dwg D2971 & Folio FA288
Descriptions: 130 - ***STOCK IN SKIDTUBE CELL***

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9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6T0.875W.058	6061-T6 Round Tube .875 X .058W	5.6660 ft (.2833 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6T0.875W.058	6	72	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Crossbolt Spacer	3.400Inches + 0.030 - 0.000	3.430 3.400		
2	Crossbolt Spacer	0.875Inches ± 0.010	0.885 0.865	Diameter	
3	Crossbolt Spacer	0.058Inches ± 0.010	0.068 0.048		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____ Description \	DISPOSITION Rework ☐ Scrap ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Cross tube ☐ Small Fab ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Prod/Store/Packaging Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
		MRB (QSI042) Approval			
		Completed By			
		Lead hand / Supervisor Approval Verification			
		QC / QA Coordinator Approval			

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Date: 07/10/18

Container No: S090635

Part: D2971

Job No: 179144

Serial No/Batch: S090635

Revision: _____
Inspector: _____
Exp Date: _____
Instructions: _____

Root Cause			
Environment	☐	No Re-verification	☐
Design	☐	Operator	☐
Doc/Data	☐	Offset/Setup	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐

Design

Centre Not Concentric

Cracks

Crimp/Kink/Ripple/Wave

Cuffs

Crushing

Heat Treat

Wave/Twist in Tube

Marks/Chatter

BOM/Route

Broken/Damage/Defect

Inspection Incomplete/Unqualified

Contamination

Countersink

Cut Too Short

Instructions Incomplete/Unclear

Drill Holes

Grain

Weld

Wrong Stock Pulled

Out of Sequence

Off-set

Mislabeled

Fit/Function

Misaligned/off center

urge

m

Positioned Wrong ☐

Outside Dimensions ☐

Over/Under tolerance ☐

Part Incorrect ☐

Part Lost/Missing ☐

Part Moved ☐

Drawing ☐

Finish ☐

Misread ☐

Turning Sequence ☐

OTHER : ☐